

What is claimed is:

1. A method for inspecting the surfaces of a three-dimensional body (2), with which at least one camera and at least one illuminating device are moved relative to the surface of the object, pictures are taken of the areas to be inspected on the surface
5 during the movement of the camera relative to the surface, and the pictures are transmitted to a computer (11) and are evaluated therein, wherein
the camera, illumination device and the surface are brought into at least one defined geometric relationship with each other during the inspection of each area to be
10 inspected on the surface, at least for period required to take a picture.
2. The method as recited in Claim 1,
wherein
the camera, illumination device and the surface are brought into several different defined geometric relationships with each other during the inspection of each area to be
15 inspected on the surface, at least for the period of time required to take a picture.
3. The method as recited in Claim 1 or 2,
wherein
the defined geometric relationship is determined by the angle between the surface normals of the area to be inspected, the illumination and the camera and/or by the
20 distance between the surface of the area to be inspected and the illumination and/or the camera.
4. The method as recited in one of the preceding Claims,
wherein
different-sized areas to be inspected are selected depending on the curvature of the
25 surface.
5. The method as recited in one of the preceding Claims,
wherein
the camera, illumination device and/or body (2) with the surface to be inspected are

movable in one or more degrees of freedom.

6. The method as recited in one of the preceding Claims,

wherein

the illumination takes place in a diffuse, directed or structured manner, as sustained
5 illumination and/or flash illumination.

7. The method as recited in one of the preceding Claims,

wherein

the illumination is alternating dark and/or bright field illumination and/or – preferably
directed – two-dimensional illumination.

10 8. The method as recited in one of the preceding Claims,

wherein

several pictures are taken of an area on a surface to be inspected under various
illumination situations and/or with different camera settings.

9. The method as recited in one of the preceding Claims,

15 wherein

several cameras and several illumination devices are combined to form at least two
subsystems (6, 7) that are movable relative to the surface to be inspected, subsystems
(6, 7) being interconnected via a communication interface, and the inspection result
being created by evaluating the images of several or all of the subsystems (6, 7).

20 10. The method as recited in one of the preceding Claims,

wherein

the evaluation of the pictures that were taken are evaluated using image-evaluation
algorithms stored in a computer system.

11. The method as recited in Claim 10,

25 wherein

specifiable structures are excepted from detection as defects during the inspection.

12. The method as recited in one of the preceding Claims,

wherein

the relative position between the surface to be inspected and the camera and/or the illumination device is detected, and the picture is taken such that it is controlled via resolution, position and/or time in accordance with the relative position.

13. The method as recited in one of the preceding Claims,

5 wherein

specifiable areas to be inspected on the surface are examined with different settings in the geometric relationship, the illumination situation and/or in image-processing parameters.

14. A system for inspecting surfaces of a three-dimensional object, in particular for

10 carrying out the method as recited in one of the Claims 1 through 13, with at least one camera for taking pictures of the areas to be inspected on the surface, and at least one illumination device, with at least one displacement device (9, 10) that moves the camera, illumination device and body (2) relative to each other, and with an evaluation unit (11) for evaluating the pictures that were taken, characterized by a control device
15 (12) set up such that the camera, illumination device and surface are in at least one defined geometric relationship with each other during the inspection of every area to be inspected on the surface, at least for the period of time required to take a picture.

15. The system as recited in Claim 14,

wherein

20 at least one camera and at least one illumination device are located in a single inspection unit (3, 4).

16. The system as recited in Claim 14 or 15,

wherein

several cameras and illumination devices and inspection units (3, 4) each represent
25 separate subsystems (6, 7).

17. The system as recited in Claim 16,

wherein

at least one stationary (6) and one movable (7) subsystem are provided.

18. The system as recited in one of the Claims 14 through 17,
wherein
the cameras are calibrated three-dimensionally.

5 19. The system as recited in one of the Claims 14 through 18,
wherein
the cameras are calibrated with reference to the illumination devices, the object and or
displacement devices.